

Date: Tuesday, 4/17/2007 3:09:08 PM  
 User: Kim Johnston

## Process Sheet

|   |                                       |
|---|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services  | Drawing Name : SPACER                 |
| Job Number : 31941                              |                                       |
| Estimate Number : 11167                         |                                       |
| P.O. Number : <u>N/A</u>                        | Part Number : D32783                  |
| This Issue : 4/17/2007 S.O. No. : <u>N/A</u>    | Drawing Number : D3278 REV B          |
| Prsht Rev. : NC                                 | Project Number : N/A                  |
| First Issue : <u>N/A</u> Type : SMALL / MED FAB | Drawing Revision : B                  |
| Previous Run : 31704                            | Material : <u>N/A</u>                 |
| Written By : _____                              | Due Date : 5/10/2007 Qty: 50 Um: Each |
| Checked & Approved By : <u>07.04.17</u>         |                                       |
| Comment : Est. A 04.04.19 New issue KJ/JLM      |                                       |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |                  |              |
|-----|------------------|--------------|
| 1.0 | MDELRINS0125X300 | Black Delrin |
|-----|------------------|--------------|



Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.8060 sf(s)

Black Delrin

Use DT8685 Router Table.

Material: Black Delrin/UHMW 0.125" thick

(M-DELRIN-S0.125x30.0)

Identify for D3278-3

Batch: m15607ml 07 04 25

(50)

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3278

Dwg Rev: BProc Rev: Bml 07 04 25

(50)

2-Deburr if necessary

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

ml 07 04 25

(50)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

ml 07/04/25 (50)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: LD Date: 07/04/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:09:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 31941

Part Number: D32783

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-C'sink as per dwg D3278

2-Deburr

ml 07/04/26

XSD

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 07/04/27 (50)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

07/4/25

7/4/26

SP

(50)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/27

(50)

Job Completion



U 07.04.27

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|  |  |                     |         |
|--|--|---------------------|---------|
| <b>DART AEROSPACE LTD</b>                  |  | <b>Work Order:</b>  | 31941   |
| <b>Description:</b> Spacer                 |  | <b>Part Number:</b> | D3278-3 |
| <b>Inspection Dwg:</b> D3278 <b>Rev:</b> B |  | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.98              | +/-0.030      | 1.988            | ✓      |        | VERN                 |          |
| 1.98              | +/-0.030      | 1.989            | ✓      |        | VERN                 |          |
| 1.480             | +/-0.005      | 1.483            | ✓      |        | VERN                 |          |
| 0.250             | +/-0.010      | 0.251            | ✓      |        | VERN                 |          |
| 1.480             | +/-0.005      | 1.478            | ✓      |        | VERN                 |          |
| 0.250             | +/-0.010      | 0.249            | ✓      |        | VERN                 |          |
| Ø0.098            | +0.005/-0.000 | 0.099            | ✓      |        | VERN                 |          |
| R0.12             | +/-0.030      | R0.12            | ✓      |        | Radius Gauge         |          |
| 0.125             | +/-0.010      | 0.125            | ✓      |        | VERN                 |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
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|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                            |                       |                            |     |
|----------------------------|-----------------------|----------------------------|-----|
| <b>Measured by:</b> ml. ml | <b>Audited by:</b> JA | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 07.04.25      | <b>Date:</b> 07/04/25 | <b>Date:</b>               | N/A |

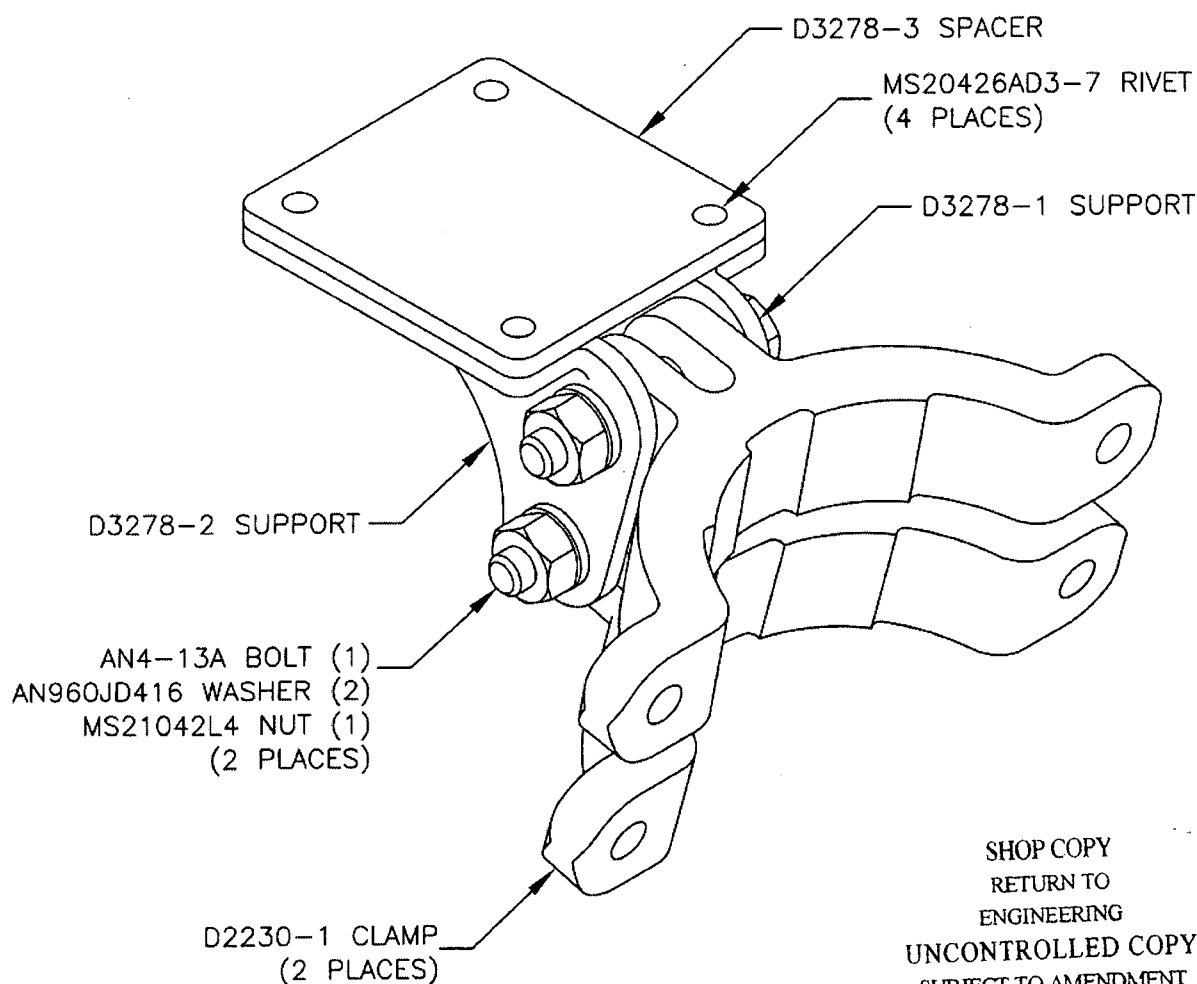
| Rev | Date     | Change                       | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A   | 04.04.19 | New Issue      P/O D3278-041 | KJ/JLM     |          |
| B   | 06.03.09 | Dwg Rev updated              | KJ/JLM     |          |
| C   | 07.02.02 | Dwg updated per JLM          | KJ/JLM     | JA       |



|         |                    |          |                    |   |                        |
|---------|--------------------|----------|--------------------|---|------------------------|
| DESIGN  | CP                 | DRAWN BY | CP                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | DRAWING NO.<br>D3278                              | REV. B<br>SHEET 1 OF 3 |
| DATE    | 05.03.31           |          |                    | TITLE<br>SUPPORT ASSEMBLY                         | SCALE<br>NTS           |
| A       | 04.03.03           |          |                    | NEW ISSUE   |                        |
| B       | 05.03.31           |          |                    | CHANGE DIM/TOL TO ENSURE FIT                      |                        |

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## D3278-041 SUPPORT ASSEMBLY



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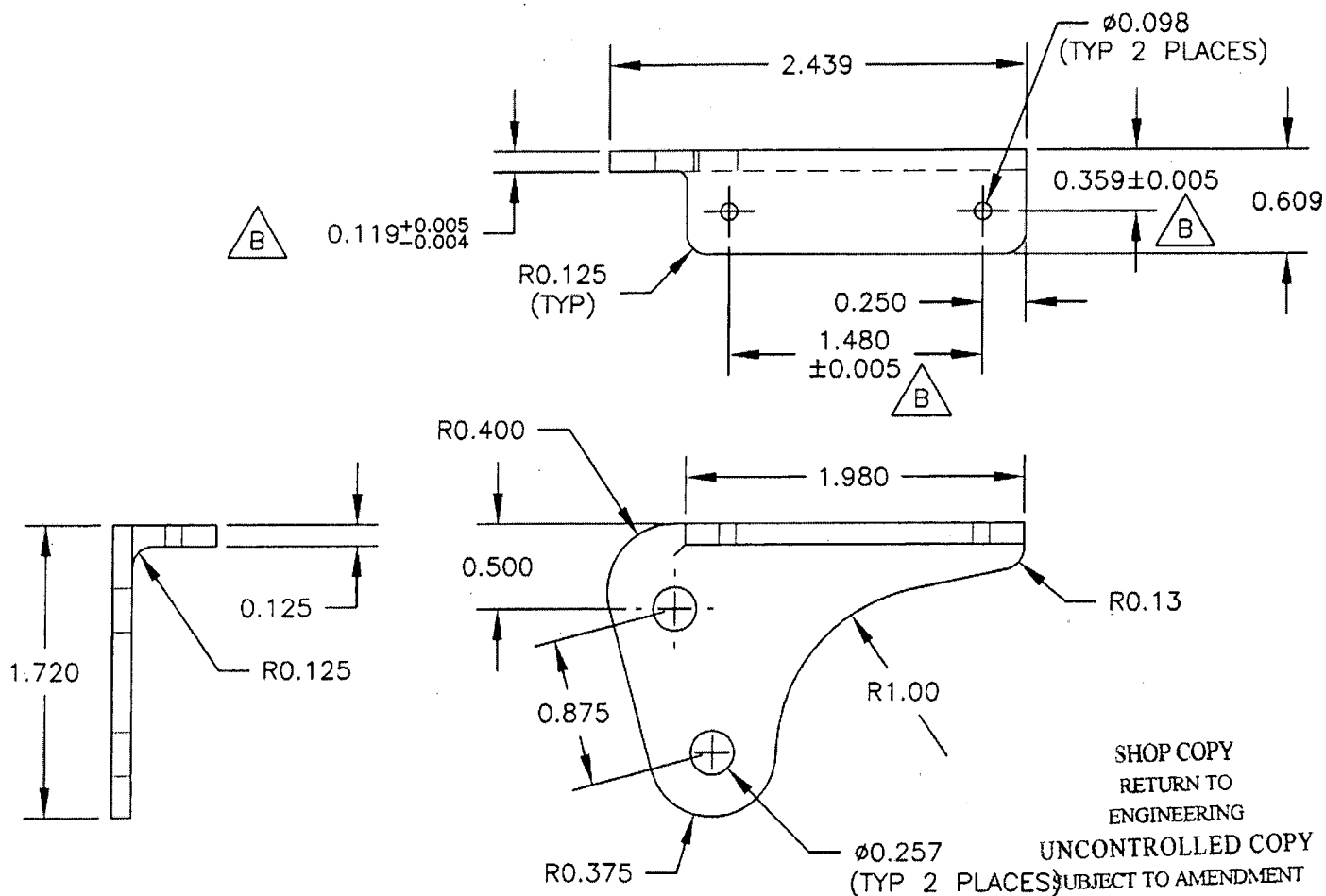
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| DATE<br>05.03.31              |                                | TITLE<br>SUPPORT ASSEMBLY                         | SCALE<br>1:1           |

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D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

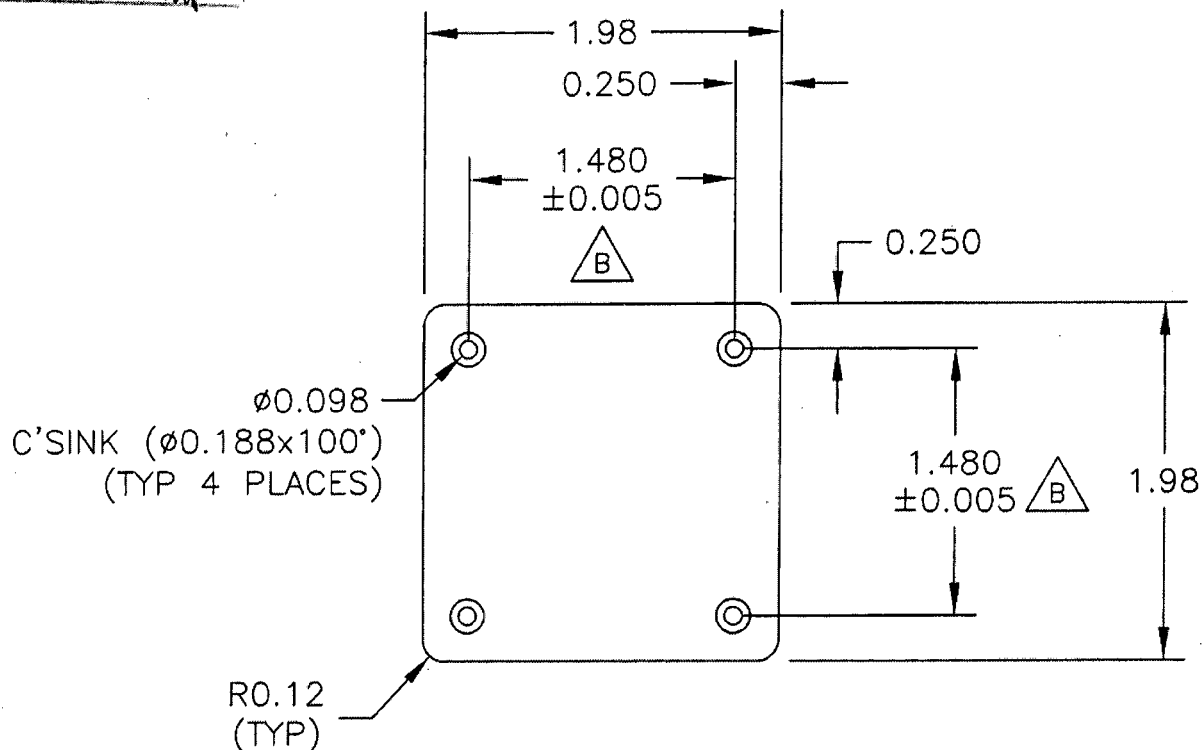
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| DATE<br>05.03.31              |                                | TITLE<br>SUPPORT ASSEMBLY                         | SCALE<br>1:1           |

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#### D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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